

Work Order ID 80086

February-09-12 4:28:25 PM

80086

Page 1

Item ID: D4527-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 09/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 12/02/10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4527

A

110

0.00

110

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT AS DWG

DWG REV: A

PROG REV: A

DEBURR

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

W 12 02 16 (10)

W 12 02 16 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Work Order ID 80086

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Page 3

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Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 09/02/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QS1005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

10 SP Feb. 21/2012.

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

10X SP 12/02/21

180

Identify as per dwg & Stock Location 51394 0.00

180

Packaging

Memo

0.00

Packaging

10X SP 12-02-22

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 80086***80086***

Page 4

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Stop ***NS2***

Item Name: Bracket

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10

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00


190

QC

Memo

0.00

Quality Control

 4.2.5 12/02/2211/202-22
110.

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

February-09-12 4:28:30 PM

Page 1

Work Order ID: 80086

80086

Parent Item: D4527-3

D4527-3

Parent Item Name: Bracket

Start Date: 09/02/2012

Required Date: 23/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 11.11.29 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X08.00 0		Purchased	No			110	f	20.7000	0.75	7.894737			

M6061T6B0 750X08 000

**

w 12.02.16

6061-T6 BAR .750" X 8.00"

Location

Loc Qty

Loc Code

MAT003

20.7

119231

20.7

B# 117085

W/O:		WORK ORDER CHANGES					
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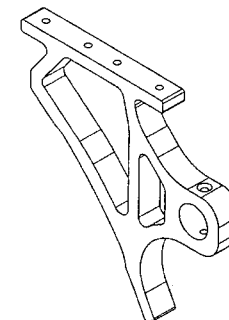
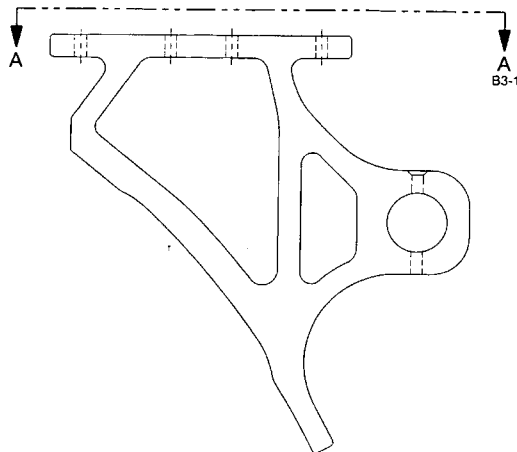
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

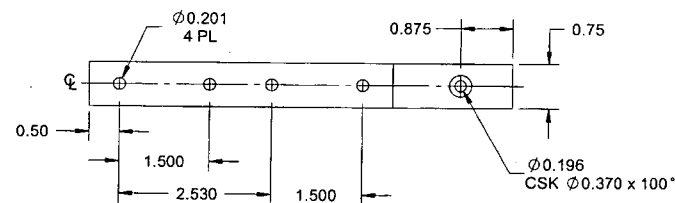
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



COPY
 TO
 COPY
 COMMENT
 THE
 R
 80086-MLJ
 12/02/10



SECTION VIEW A-A D6-1

D4527-1 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
 PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
 OR ASTM B211 OR ASTM B221
 OR 6061-T6/T62 ALUMINUM SHEET
 PER QQ-A-250/11 OR AMS-QQ-A-250/11
 OR AMS 4025 OR AMS 4027
 OR ASTM B209
 REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.81 lbs

RELEASE
 2011-11-28
 JWP

A		NEW ISSUE		RF	11.11.22
REV.		DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA			
DRAWN	RF				
CHECKED	RF	DRAWING NO. D4527			REV. A
MFG. APPR.	RF				SHEET 1 OF 4
APPROVED	RF	TITLE			SCALE
DE APPR.	RF	BRACKET — —			NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASE
2011-11-28

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4527	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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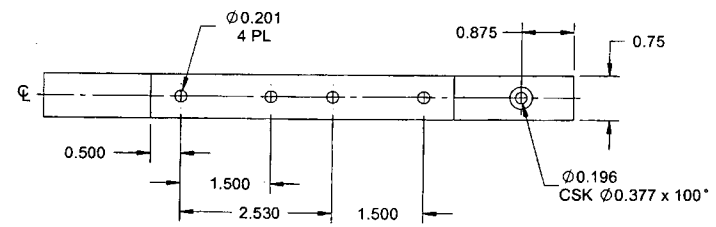
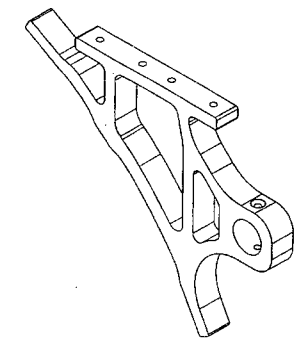
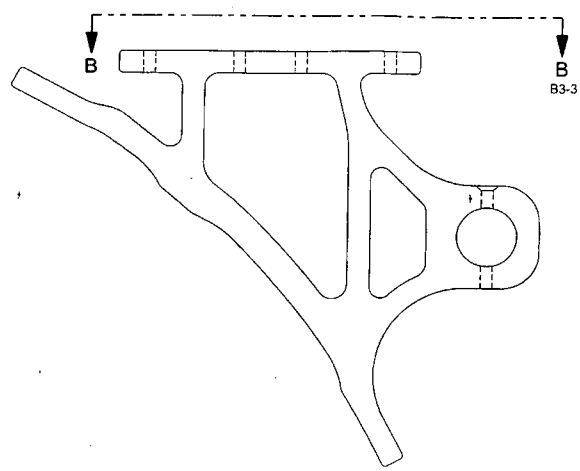
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NOTE: Date & initial all entries

80086



SECTION VIEW B-B B5-3

D4527-3 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.90 lbs

RELEASED
2011-11-28

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4527	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
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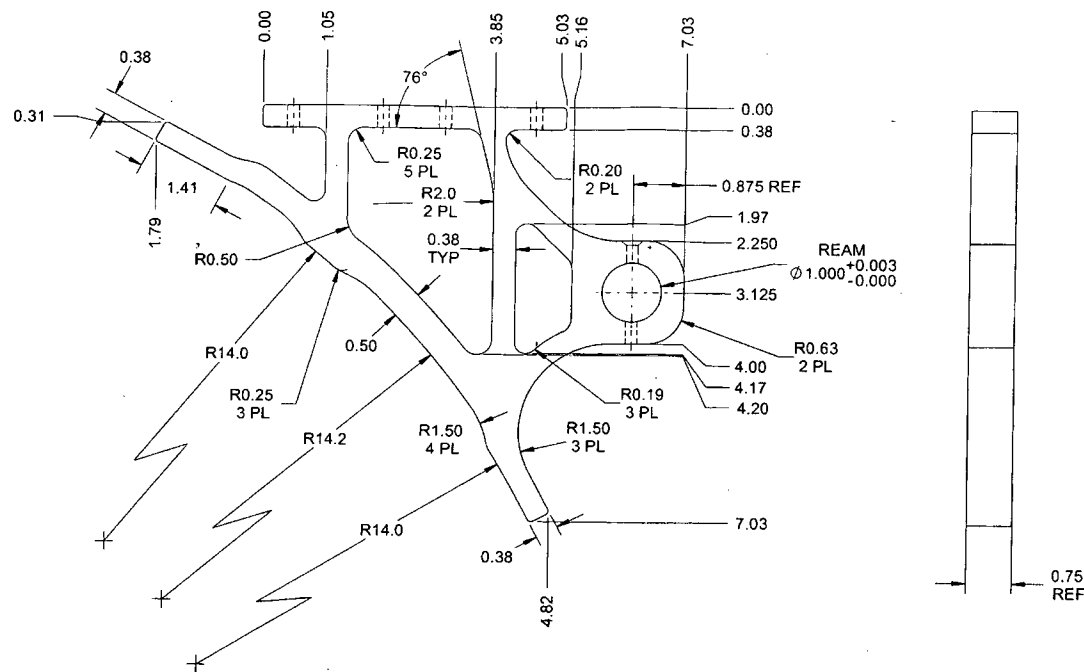
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NOTE: Date & initial all entries

20096



D4527-3 BRACKET

RELEASED
2011-11-28

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4527	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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